

Work Order ID 81757***81757***

Page 1

Item ID: D3914-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Long Basket Lid Assembly (350)

Start Date: 3/19/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/19/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: *mk*Date: *12-03-16* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3914

B

D4020

A

100

Weld per dwg A/R S.S. rod Batch: *118366* 0.00***100***

Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble ribs , weld as per dwg D3914 using DT9607A

2- weld hinge (3) and Mounting brackets as per dwg D3914

Visual inspect before welding mesh

3- tack weld mesh on basket as per dwg D3914

***Cut out mesh where label plate goes in center off basket lid as per dwg
D4020-5. Make sure to place mesh correctly on lid, check with label plate before
tacking mesh****IX* *Ø* *Rpl*
12.04.13

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Memo

0.00

Quality Control

ll BE
12.04.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81757

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Page 2

Item ID: D3914-041 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Long Basket Lid Assembly (350)
 Start Date: 3/19/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 3/19/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC6- Inspect dimensions to drawing

0.00

Sizku 115

120

QC

Memo

0.00

Quality Control

130

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

130

Powdercoat

Memo

0.00

Powder Coating

*** mask sides of hinge prior to powdercoat***

Start Time: *8:30*

Oven Temperature: *320 °F*

Finish Time: *9:00*

140

Wing Walk as per dwg QSI005 4.4 Batch *120902* 0.00

140

HandFinish

Memo

0.00

Hand Finishing

1- Mask data plate and apply wing walk on outside surface of mesh as per dwg

2- Install placard and label as per dwg

Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label

IX *✓* *M-L*
12/04/16

1 *✓* *12-4-16*

M 117338

W/O:		WORK ORDER CHANGES					
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Page 3

Item ID: D3914-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Long Basket Lid Assembly (350)
Start Date: 3/19/2012 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 3/19/2012 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00				(1x)	Ø		EP 12/04/16
Quality Control									
160	Identify as per dwg & Stock Location: <i>GA</i>	0.00							
160									
Packaging	Memo <i>w/o 82880</i>	0.00				(1x)	Ø		EP 12/04/16
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							12/4/17 <i>MF</i>
Quality Control									<i>MF</i> 12-04-16

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 81757

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 3/19/2012

Required Date: 3/19/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
10.08.18 verified by:EC

IPP Rev:B as per dwg revB DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2581 Mounting Bracket		Manufactured	No			100	Each	23.0000	2	SAB ²		12-04-10	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		23							
				69739		1							
				70766		2							
				77045		1							
				77523		19		81253	2				
D3914-1 Rib		Manufactured	No			100	Each	0.0000	2	SAB ²		12-04-11	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		2							
				WA006		-2		382130	2				
D3914-7 Rib		Manufactured	No			100	Each	12.0000	2	SAB ²		12-04-11	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA006		12							
				80164		2							
				81208		10		381447	2	381453			
D4016-3 Hinge Half, Lid		Manufactured	No			100	Each	15.0000	3	SAB ³		12-04-12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		15							
				78495		15		381389	3				
D4018-5 Rib		Manufactured	No			100	Each	36.0000	9				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		36							
				78041		35							
				80597		1							
										381447	→ ⑧	Pl 12-04	
										382699	→ ①		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 2

Work Order ID: 81757

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 3/19/2012

Required Date: 3/19/2012

Start Qty: 1.00

Required Qty: 1.00

D4020-5 Manufactured No
Mesh (350 Basket Long, Lid)

100 Each 5.0000

1 1

Pl 12-04-14

Location

Loc Qty

Loc Code

WA

5

78698

1

81180

4

B81446 → ①

D4021-3 Manufactured No
Data Plate

100 Each 2.0000

1 1

Pl 12-04-12

Location

Loc Qty

Loc Code

WA005

2

75460

2

B82507 → ①

D4035-041 Manufactured No
Lid Rib Assembly, Fwd (350 Basket)

100 Each 2.0000

1 1

SAN 12-04-11

Location

Loc Qty

Loc Code

WA006

2

74642

2

B87701

①

D4035-043 Manufactured No
Lid Rib Assembly, Aft (350 Basket)

100 Each 6.0000

1 1

SAN 12-04-11

Location

Loc Qty

Loc Code

WA006

6

81201

6

B81452

①

D2728-3 Manufactured No
Dart Logo label

140 Each 0.0000

1 1

115050

1

BL 12-4-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

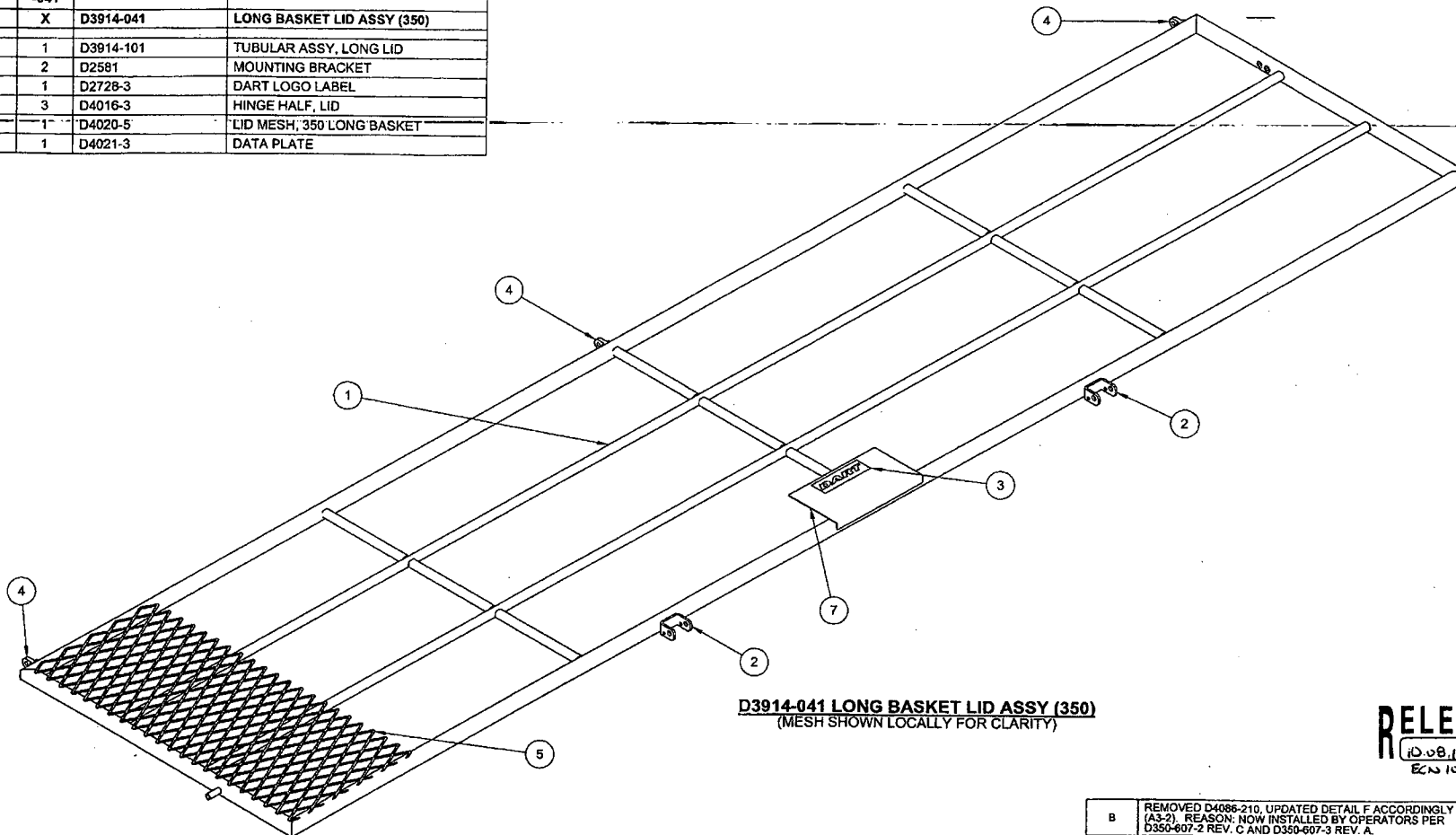
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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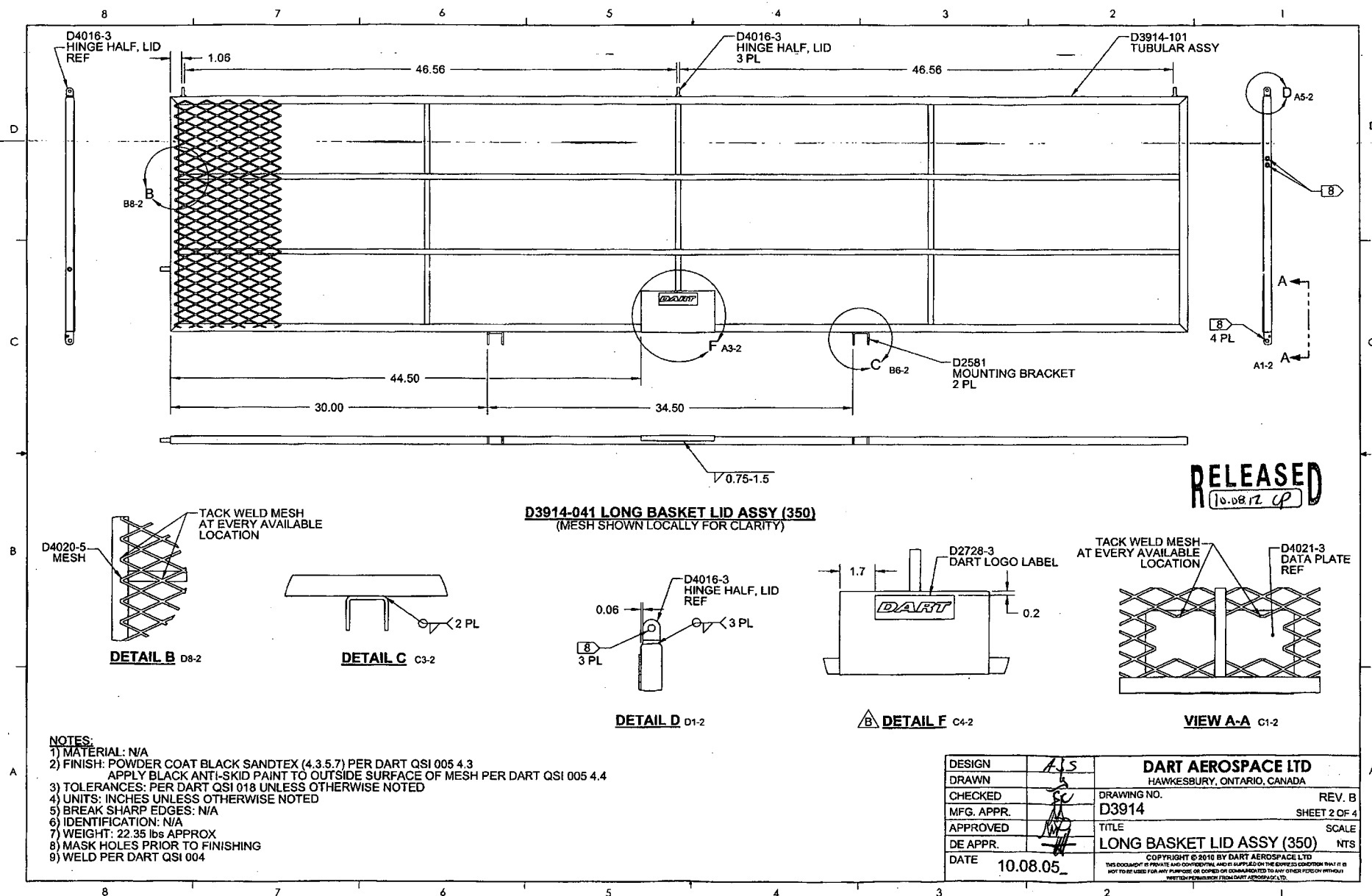
ITEM	QTY	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE



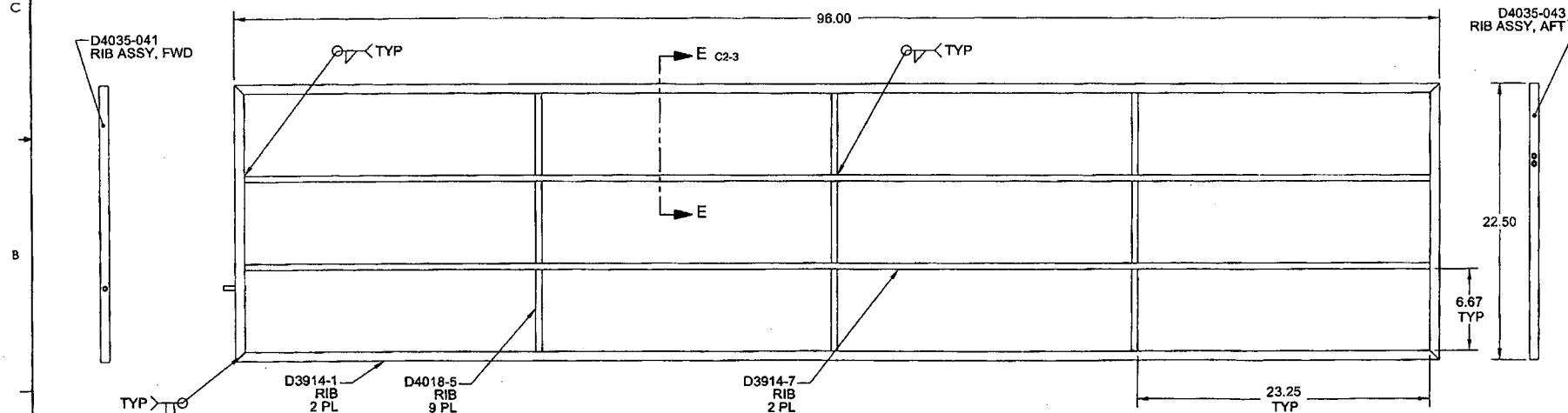
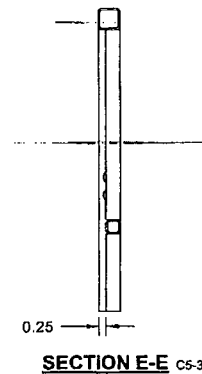
D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.17 CP
ECS 10-596

B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	ALS		
DRAWN	SC		
CHECKED	SC		
MFG. APPR.	SC		
APPROVED	SC		
DE APPR.	SC		
DATE	10.08.05		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3914 SHEET 1 OF 4 TITLE LONG BASKET LID ASSY (350) SCALE NTS <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			



ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



8 D3914-101 TUBULAR ASSY, LONG LID

RELEASED
10-08-12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.10 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RC	DRAWING NO.	REV. B
CHECKED	RC	D3914	SHEET 3 OF 4
MFG. APPR.	RC	TITLE	SCALE
APPROVED	RC	LONG BASKET LID ASSY (350)	NTS
DE APPR.	RC	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.08.05		

